

Date: Wednesday, 1/30/2008 7:53:07 AM
 User: Kim Johnston

Process Sheet

SPLIT-23

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 37059 -2
 Estimate Number : 11341
 P.O. Number :
 This Issue : 1/30/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : LARGE FAB ASSY
 Previous Run : 35442
 Written By :
 Checked & Approved By : JA 08 01 30
 Comment : Est: A 05.01.13 New issue KJ/JLM

Drawing Name : PIN ASSEMBLY
 Part Number : D3332043
 Drawing Number : D3332 REV. A1
 Project Number : N/A
 Drawing Revision : A1
 Material :
 Due Date : 2/5/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M1018R0500 1018-1025 Steel Bar



Comment: Qty.: 0.1749 f(s)/Unit Total: 1.7493 f(s)

1018-1025 Steel Bar

Material: AISI 1018-1025 Ø0.500" Round Bar

(M1018-R0.500)

Identify for D3332-37

Batch: M10634

M106996

J.F. 08/05/03 J.F. 08/02/01

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine D3332-7 as per Folio FA493 and Dwg D3332

J.F. 08/05/03 J.F. 08/02/01

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/05/03 J.F. 08/02/01

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8F 08/05/23

8F 08/02/01

5.0 M1018R0313 1018-1025 Steel Bar



Comment: Qty.: 0.2836 f(s)/Unit Total: 2.8361 f(s)

1018-1025 Steel Bar

Material: AISI 1018-1025 Ø0.313" Round Bar

(M1018-R0.313)

Identify as D3332-9

Batch: M107436

NALU

Date: Wednesday, 1/30/2008 7:53:07 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 37059

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Fabricate D3332-9 as per Dwg D3332

7.0

D33321

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Handle Assembly

Pick:

Qty Part Number Description Batch

1 D3332-1 Handle

A/R N/A Steel Rod

Identify as D3332-043

Handwritten:
SOLD
p feedback
25 is
W

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble and Weld using D3332-04 T1 as per Dwg D3332

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Cover thread only for D3332-9 prior to painting

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 37059

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

PACKAGING 1

PACKAGING RESOURCE #1



SHIPPED
TO
RED BARN
AS IS. W

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/19

Comment: FINAL INSPECTION/W/O RELEASE

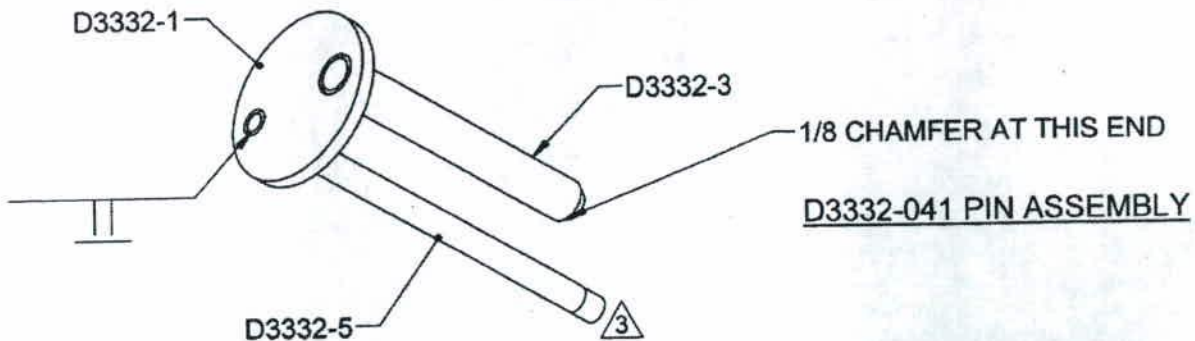
Job Completion



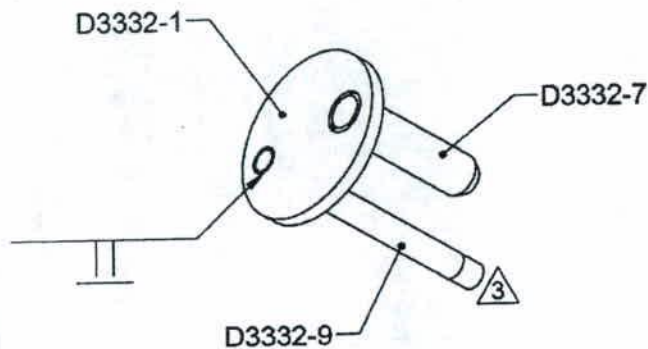
u 09-06-19

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE ± 0.000 ± 0.005	

**D3332-041 PIN ASSEMBLY**

RELEASED
[Signature]
05/02/09

**D3332-043 PIN ASSEMBLY****NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

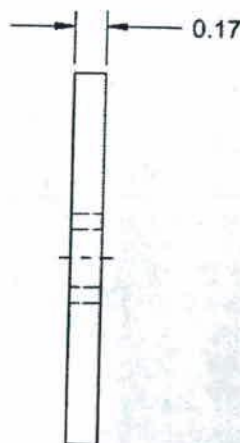
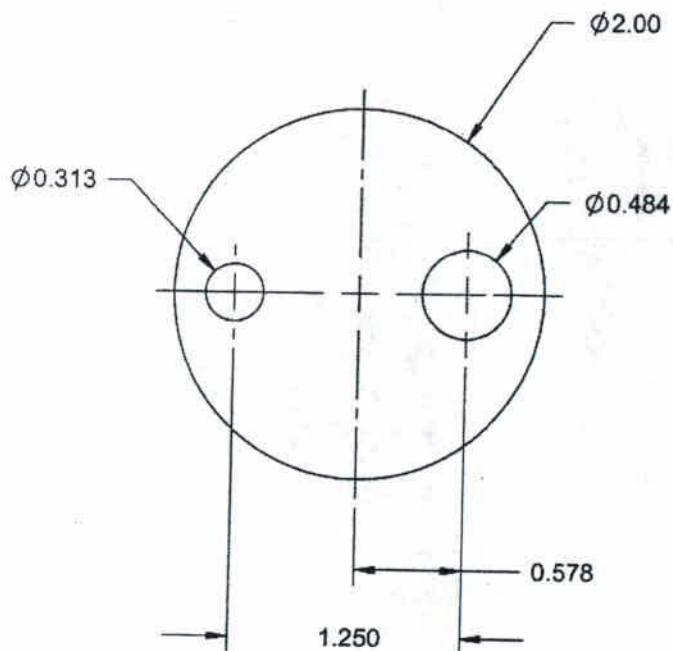
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DATE 04.12.14		TITLE PIN ASSEMBLY	SHEET 2 OF 4 SCALE 1:1



RELEASED
[Signature]
05/04/09

D3332-1 HANDLE**NOTES:**

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

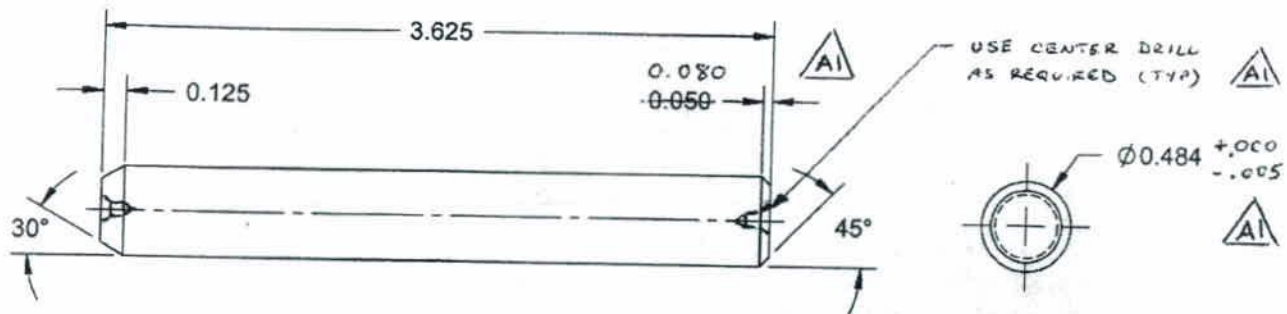
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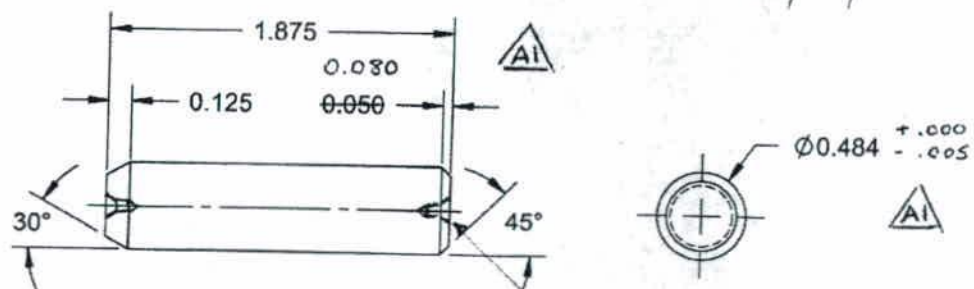
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DATE 04.12.14		TITLE PIN ASSEMBLY	SHEET 3 OF 4
			SCALE 1:1

**3332-3 PIN**

RELEASED
[Signature]
05/02/09

**3332-7 PIN**

USE CENTER DRILL
AS REQUIRED (TYP)
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NOTES:

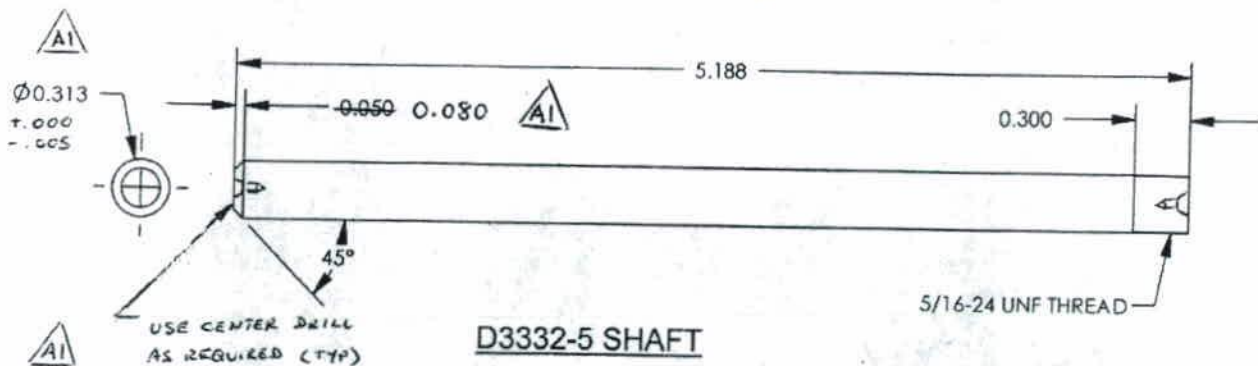
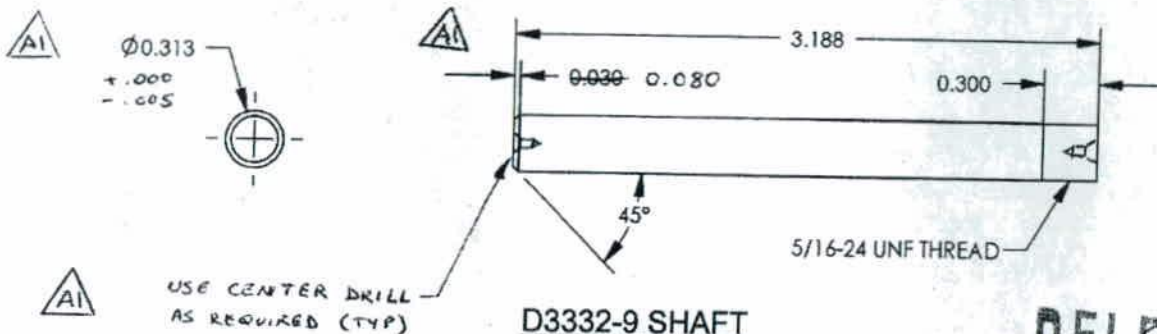
- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018R0.500)
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- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1

**D3332-5 SHAFT****D3332-9 SHAFT****NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

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